

Date: Friday, 08/08/2008 10:39:52 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE AND LOCK- DOWN ASSY
 Job Number : 41076
 Estimate Number : 13446
 P.O. Number : Part Number : D3451041
 This Issue : 08/08/2008 S.O. No. : Drawing Number : D3451 REVA
 Prsht Rev. : NC Project Number : N/A
 First Issue : // Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 40605 Material :
 Written By : Due Date : 15/08/2008 Qty: 5 Um: Each
 Checked & Approved By : mf 08-08-08
 Comment : Est Rev:A 08-06-27 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34511 Tube Handle Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube Handle Arm

batch: B39955 ✓

SP 08-08-11 (10x) (5x)

2.0 GP211 Rubber Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Handle

batch: M108392

SP 08/08/11 (5)

3.0 PB6743001103 Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Handle

batch: B41066

SP 08-08-11 (5x)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg PB67-43001

SP 08-08-11 (5x)

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08/08/11 (5)

Date: Friday, 08/08/2008 10:39:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 41076

Part Number: D3451041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/11 (5)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(5X)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-h / [signature]

08-08-11

8.0 POWDER COATING POWDER COATING



(5X)

Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316

START TIME:

8-00

OVEN TEMPERATURE:

320°F

FINISH TIME:

8-30

M-h 08/08/12

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FY 08/08/12 (5)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- assemble rubber handle as per dwg PB67-43001

SD 08/08/14

(5)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/15 (5)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pat E.

AS 08/08/26 12

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

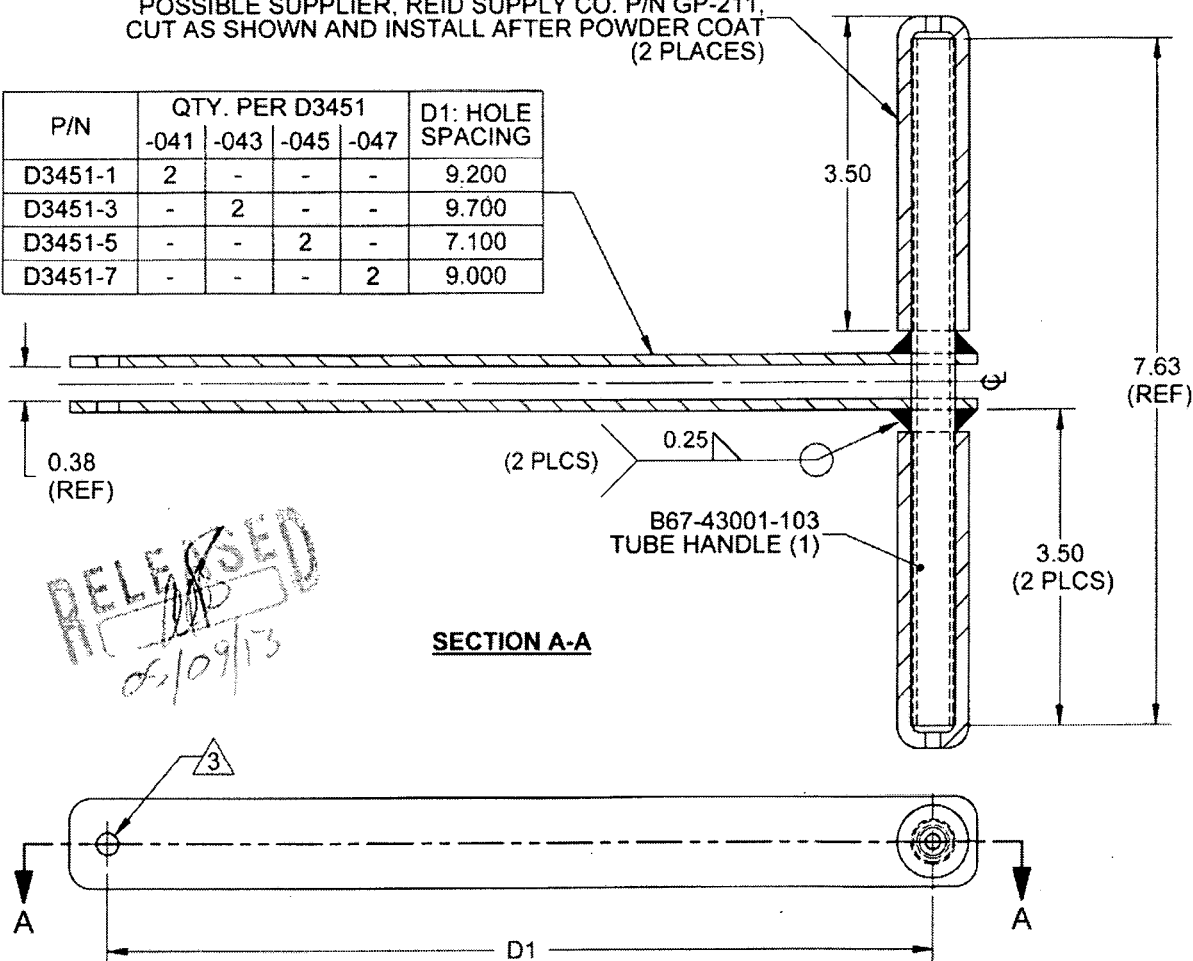
u 08/08/26



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE 05.08.25	TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2		
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



SECTION A-A

D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

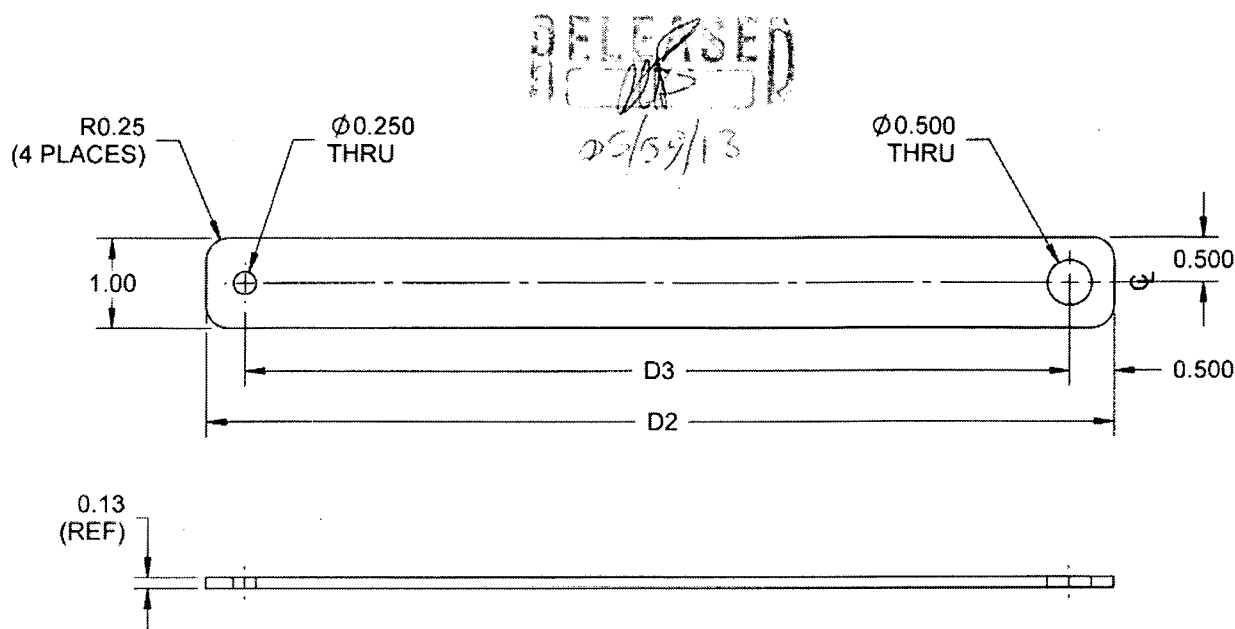
- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2	



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

41076

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303
D3451-5 SUPERSEDES PREMIER P/N B67-43001-301
D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.